

Date: Thursday, 4/12/2007 9:07:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 31756		
Estimate Number	: 10310		
P.O. Number	: N/A	Part Number	: D26175
This Issue	: 4/12/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2617 REV D2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31610	Drawing Revision	: D2
	Type : MACHINED PARTS	Material	: N/A
Written By	:	Due Date	: 4/13/2007
Checked & Approved By	:	Qty:	100 Um: Each
Comment	: Est H 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T0500W058 6061-T6 Tube .500 x.058W



Comment: Qty.: 0.0205 f(s)/Unit Total: 2.0475 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch ~~00~~ M109007

J.F 07/04/17

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

J.F 07/04/17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F 07/04/17

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/04/17 (100)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

J.F

07/04/23

(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/04/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:08:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31756

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

9/20/04/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/20/04/23 (100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(100)

Comment: FINAL INSPECTION/W/O RELEASE

9/20/04/24

Job Completion



U 07/24/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

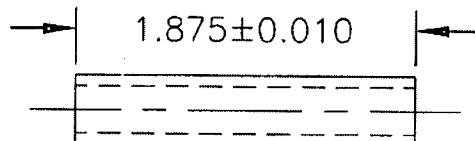
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

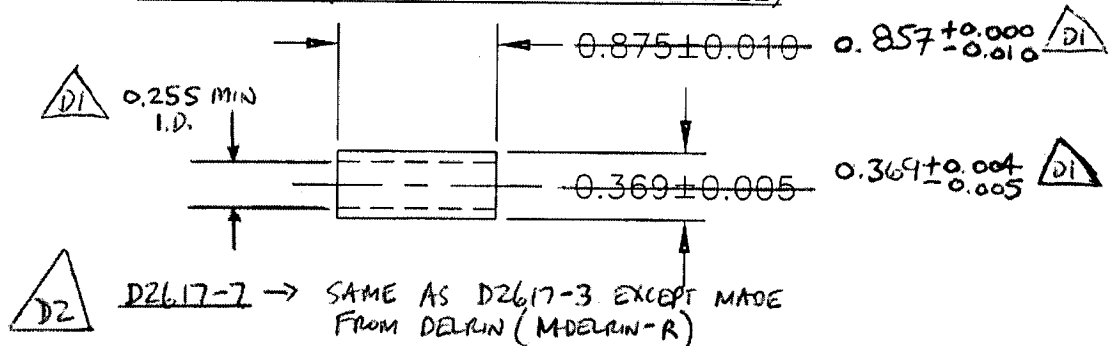


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.09.10	#	CP	ADD D2617-7	
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
D1	CP	#	04.07.12	CORRECT TOLERANCE (NCR 779)	

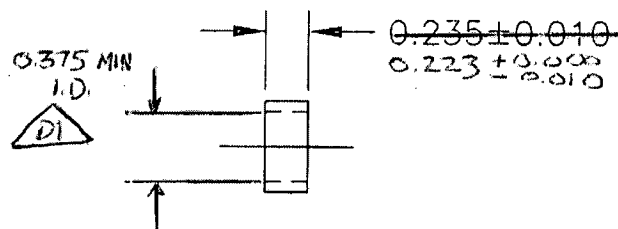
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31756

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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